

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013097**Date Inspected:** 03-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress:

Segment # 7AE-PP48**Repair Welding.**

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG034A-007; The Critical Welding Repair Report (CWRR) was B-CWR1211. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. See the attached below Photo.

Segment # 7AE

This QA Inspector observed ZPMC personnel Performed Snug tightening at Segment 7AE & 7BE Panel Point -48 ~ 51 Bike path, lower Chevron & Upper Chevron Brace.

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Segment # 7AE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048047 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA033-034; The Welding Repair Report (WRR) was B-WR11081. ZPMC QC is identified as Mr.Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. See the attached below Photo.

Segment # 7BE-7CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 220066 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG036C-043; The Welding Repair Report (WRR) was B-WR10512. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)Repair

Segment # Cross Beam- 7

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 037780 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB201A-007-005; The Critical Welding Repair Report (CWRR) was B-CWR1226. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) FCM-Repair-1

Segment# 7AW –PP49

This QA inspector observed, Heat Straightening Perform ZPM QC is identified as Mr.Feng Ya Jun. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8235.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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